

Claims:

1. Station, in particular machining, measuring, conveying station and the like which is arranged in particular in a machine line with a central control unit, with at least one control unit with a control panel for indication, control and/or diagnosis functions of the station, the control panel (6) being able to act portably and wireless at least upon the control device (5) of the station, **characterised in that** a locally binding device is provided and the portable control panel (6) can act upon the control device (5), respectively the station (1-4), only when the locally binding device is activated.
2. Station according to claim 1, **characterised in that** the station (1-4), respectively the central control device (II), and the control panel (6) are connected to each other by at least one transmitter (7) each and at least one receiver (8) each, and that the control panel (6) has a transmitter/receiver unit (17, 18) for a bidirectional communication with the station (1-4), respectively the central control unit (II).
3. Station according to claim 1, **characterised in that** at least one control panel (6) can be connected with several stations (1-4) simultaneously or one after the other.
4. Station according to claim 1, **characterised in that** the control panel (6) acts indirectly over the central control unit (II) or directly on the control device (5) of the station (1-4).

5. Station according to claim 1, **characterised by** uniform function, indication and control programmes of the control panels (6) for the stations (1-4), respectively their control devices (5), in such a way that a uniform operation of the different stations is possible independently from the respective type of machine.
6. Station according to claim 1, **characterised in that** the control panel (6) is connected wireless with the central control unit (II) of the machining and production line (I) in such a way that programmes and functions of the central control unit (II) from the control panel (6) for the machining and production line (I), respectively for a particular station, can be called and/or activated, respectively can be transmitted to the control panel.
7. Station according to claim 1, **characterised in that** the station (1-4) has a definite station codification and because of the station codification in the control panel (6) the respective programmes and functions for the station can be activated.
8. Station according to claim 1, **characterised in that** the control panel (6) has a definite control panel codification.
9. Station according to claim 1, **characterised in that** certain programmes, functions, authorisations, respectively areas of responsibilities, can be allocated to the service person through the control panel (6) via an identifying device, for example a key-operated switch, password check via input and view panel, magnetic strip reader, smart card, transponder or the like.

10. Station according to claim 1, **characterised in that** the wireless connection is an electromagnetic connection, for example a radio link, an infrared or optical connection.
11. Station according to claim 1, **characterised in that** the control panel (6) has voice select menus by means of which voices can be set.
12. Station according to claim 1, **characterised in that** the locally binding device is designed as additional wireless connection between the control panel and the station, respectively the machining and production line.
13. Station according to claim 1, **characterised in that** the locally binding device is realised in an arrangement which is separated from the control panel, in particular from the person identifying apparatus, and the locally binding device can only be activated when the service person carrying this arrangement is within the range of the station.
14. Station according to claim 1, **characterised in that** the locally binding device is formed by means of a locating arrangement for the continuous identification of the location either of the control panel or the service person, and the locally binding device can only be activated when the location is in the range of the station.
15. Station according to claim 1, **characterised in that** the locally binding device is designed as electromagnetic, mechanic, electric or optically acting switch.

16. Station according to claim 1, **characterised in that** the locally binding device can only be activated within a pre-defined distance between the service person and the station.
17. Station according to claim 1, **characterised in that** the locally binding device is designed as connection operating in the radio band or in the IR spectral range.
18. Station according to claim 1, **characterised in that** the locally binding device can be activated by receiving the signal emitted by the control panel through the receiver with minimum signal intensity.
19. Station according to claim 1, **characterised in that** the locally binding device can be activated by receiving the signal emitted by the control panel through several, if necessary pre-defined, receivers.
20. Station according to claim 1, **characterised in that** the control panel (6) is designed as a control panel unit which is worn on the head and has in particular a goggle-like form.
21. Station according to claim 1, **characterised in that** the control panel (6) is designed as a control panel unit worn on the head and that it has a visor by means of which information for the service person (9, 10) is indicated.
22. Station according to claim 1, **characterised in that** the control panel (6) has a voice input and output system, through which the communication between the service person (9, 10) and the control panel (6) is carried out.

23. Station according to claim 1, **characterised in that** the control panel (6) has sensors for the activity of the service person which recognise irregularities of the service person (9, 10) and, if necessary, activate an emergency programme, in particular activate a stopping of the station or the production line.
24. Station according to claim 1, **characterised in that** the control panel (6) has a data input and a data indication device, in particular a touch-sensitive screen for control, indication, input, respectively service, functions.
25. Station according to claim 1, **characterised in that** the stations (1 - 4) on occurring error messages, respectively pending jobs, if necessary depending from the kind of error, respectively job, transmit error information, respectively job information, to a control panel (6), depending from the kind of error, respectively job, to a special control panel (6).
26. Station according to claim 1, **characterised in that** the control panel (6) has an acoustically, optically and/or mechanically acting information unit which is activated by the arrival of an error or job information.
27. Station according to claim 1, **characterised by** a digitalized data transfer of the wireless connection.
28. Station according to claim 1, **characterised in that** the central control unit (II), respectively the station (1 - 4) or the control panel (6) also protocols and, if necessary, stores the individual programmes/functions carried out on the station via the control panel (6).

29. Station according to claim 1, **characterised in that** the wireless connection between the control panel (6) and the control unit (5) is carried out via radio, in particular in a frequency range between 200 megahertz and 100 gigahertz, preferably between 1 and 10 gigahertz, in particular between 2 and 3 gigahertz, as well as between 4 and 6 gigahertz.
30. Station in particular machining, measurement, conveying station and the like which in particular is arranged in a machine line with at least one control unit with control panel for indication, control and/or diagnosis functions of the station, the control panel (6) being able to act, portably and wireless, at least upon the control device (5) of the station, **characterised in that** the wireless connection between the control panel (6) and the control device (5) is carried out via radio, in particular in a frequency range between 200 megahertz and 100 gigahertz, preferably between 1 and 10 gigahertz, in particular between 2 and 3 gigahertz, as well as 4 and 6 gigahertz.
31. Machine line with at least one station (1-4), in particular machining, measurement, conveying station and the like, with at least one control device with control panel for indication, control and/or diagnosis functions of the station as well as a central control unit of the machine line, the control panel (6) being able to act, portably and wireless, at least upon the control device (5) of the station, **characterised in that** a locally binding device is provided and an influence of the portable control panel (6) on the control device (5), respectively the station (1-4) is possible only when the locally binding device is activated.

32. Machine line according to claim 31, **characterised in that** several stations (1-4) are connected via a common transmitter (7) and receiver (8) with at least one control panel (6) and/or the central control unit (II).
33. Machine line according to claim 31, **characterised in that** the central control unit (II) is designed as central computer.
34. Machine line according to claim 31, **characterised in that** the stations (1-4) of the machining, respectively production, line as well as the central control unit (II) are connected to each other by a data network and the transmitter/receiver (7, 8), respectively the locally binding device, is either indirectly connected via the station or directly with the data network.
35. Machine line according to claim 31, **characterised in that** the machine line is designed as machining line, respectively as production line.
36. Method for establishing a communication for indication, control, and/or diagnosis purposes between a control panel and a station, in particular machining, measurement or conveying station, a plurality of stations being arranged in a machine line and the stations being connected by a data network to each other and with a central control unit of the machine line, at first a communication channel being established between the control panel and the station, at least the station codification being transmitted into the control panel and, because of the station codification the respective programmes, respectively the functions, for the station becoming able to be operated on the control panel.

37. Method according to claim 36, **characterised in that** the station can only be operated when the locally binding device is activated.
38. Method according to claim 36, **characterised in that** simultaneously, before or after establishing the communication channel the locally binding device is checked and, if the checking is positive, the locally binding device is activated.
39. Method according to claim 36, **characterised in that** with the locally binding device it is checked whether a further signal serving the locally binding device has been sent from the control panel and is received by the receiver.
40. Method according to claim 36, **characterised in that** with the locally binding device it is checked whether switches located in the range of the station are operated by the service person.
41. Method according to claim 36, **characterised in that** the control panel depending on the station codification is fed with the respective programmes/functions from the central control unit (II).
42. Method according to claim 36, **characterised in that** the service person is identified via an identifying device on the control panel and is, user-dependent, supplied with the respective programmes/functions.
43. Method according to claim 36, **characterised in that** one control panel is connected simultaneously with two or more stations.



44. Method according to claim 36, **characterised in that** one station is connected simultaneously with two or more control panels.
45. Method according to claim 36, **characterised in that** before the control panel can access the station for indication, control and/or diagnosis purposes, the identity of the service person who has been determined by the identifying device is checked in the central control unit and because of this checking programmes, functions, authorisations, respectively areas of responsibility intended for the service person are cleared and after this clearing the control panel accesses the station in the frame of the above mentioned clearing directly.

Patent Attorney